

Date: Thursday, 1/17/2008 3:32:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STUB COVER
Job Number	: 36863		
Estimate Number	: 12415		
P.O. Number	:	Part Number	: D34941
This Issue	: 1/17/2008 S.O. No. :	Drawing Number	: D3494 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 28946	Material	:
Written By	:	Due Date	: 1/30/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>08 01 18</u>		
Comment	: Est Rev: A New Issue 06-05-18 JLM est rev B ecn 888 06.12.13 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.6972 sf(s)/Unit Total : 8.3664 sf(s)
 304/316 .063 Sheet
 (M304S16GA)
 Batch: 106653 HB 8-1-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3494
 Dwg Rev: B HB 8-1-21 (12)
 Prog Rev: B
 2-Deburr if necessary HB 8-1-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form as per Dwg D3494

HB 08/01/22 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:32:20 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUB COVER

Job Number: 36863

Part Number: D34941

Job Number:



PKO →

Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-24

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3494

A/R SS ROD Batch: M106115

08/01/28

12x

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-01-28

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/28 (4R)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

08-01-31

(12x)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-31 (12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/2/1 50 (12x)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/04 (12)

Job Completion



08/02/04

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

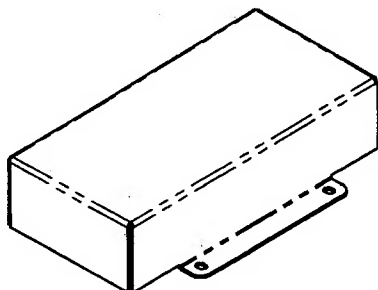
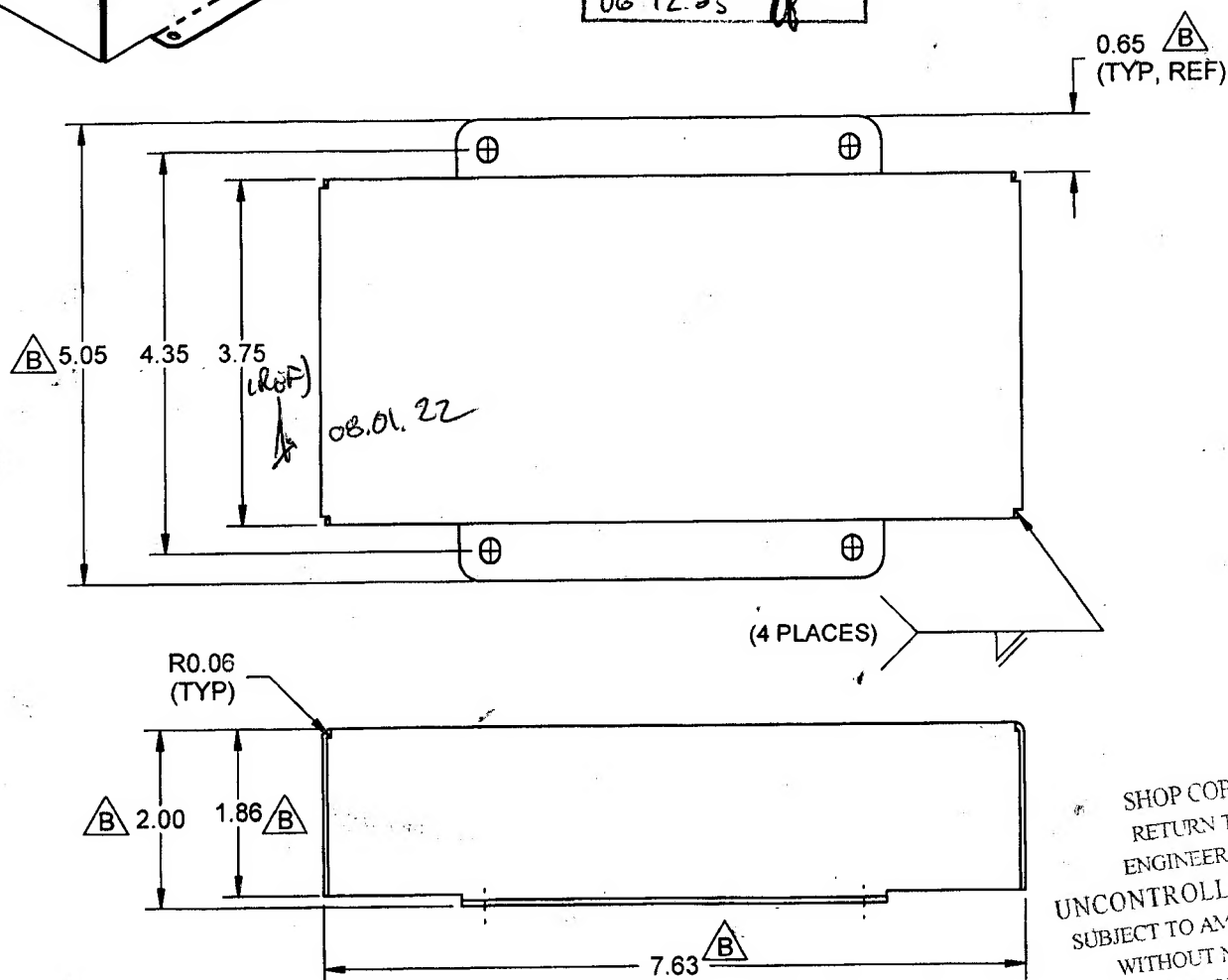
Part No: D3494 PAR #: 08-003 Fault Category: Eng Design NCR: ~~Yes~~ No DQA: D Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR: <u>36863</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.01.22	7.0	G.67 SHOULD HAVE BEEN CORRECTED TO G.725. ADDED (REF) TO 3.75 DIA TO KEEP CENTER TO CENTER OF HOLES (4.35). THIS INCREASE GAP BETWEEN CORNER. LARGE WELD BANDS REQUIRED. R.C. Dwg not updated with the current dimensions	<u>08.01.22</u>	Parts acceptable per Eng. See PAR 08-003 for dwg change.	<u>N/A</u> <u>If</u>	<u>08-01-22</u>	<u>08.01.22</u>	<u>08.01.22</u>

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3494	REV. B SHEET 1 OF 2
DATE 06.11.28	TITLE STUB COVER	SCALE 1:2	
REV	DATE	DESCRIPTION	
A	06.01.16	NEW ISSUE	
B	06.11.28	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES	

**RELEASED**06.12.05 *PH***NOTES:**

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

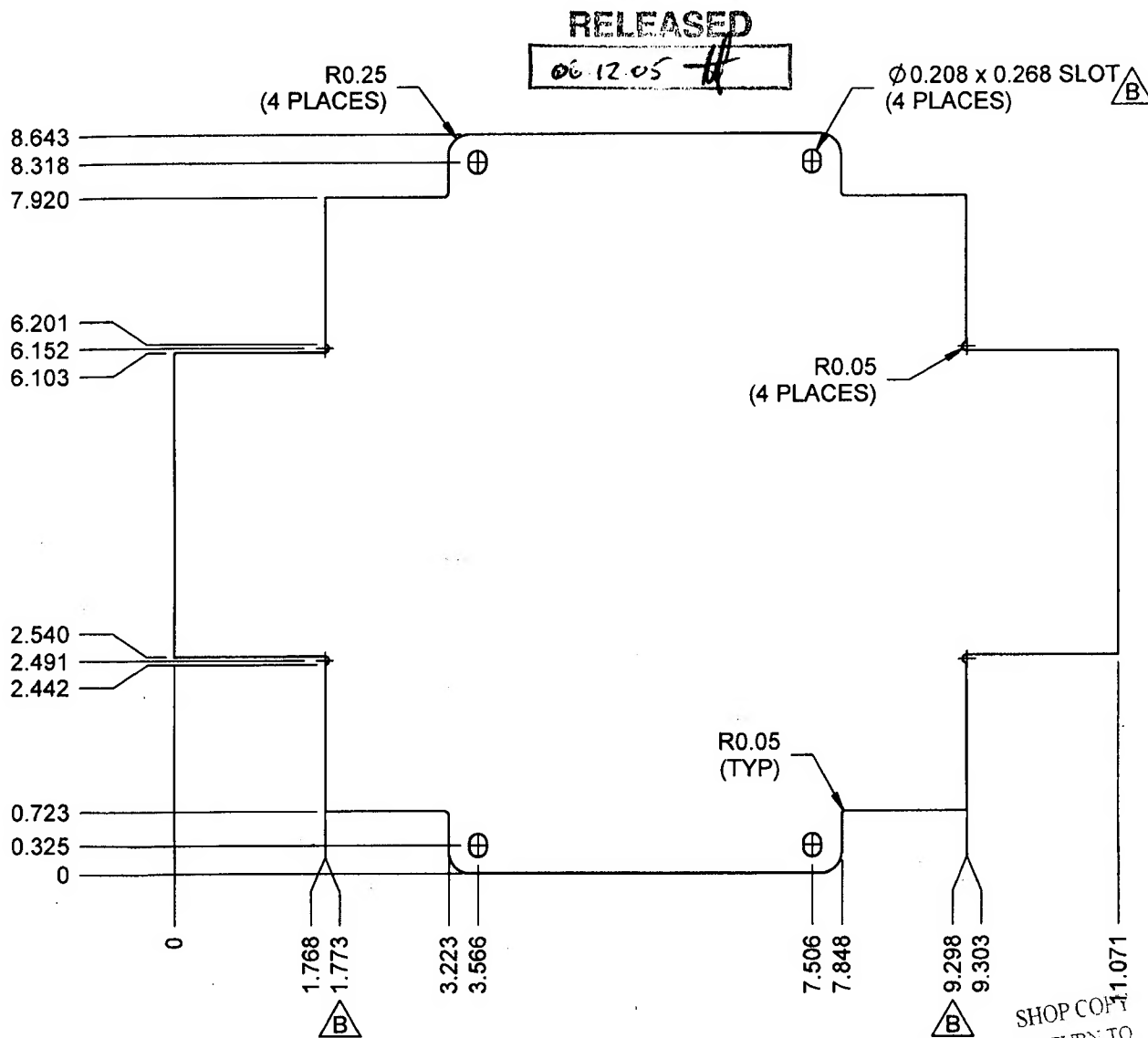
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3494	REV. B SHEET 2 OF 2
DATE 06.11.28	TITLE STUB COVER		SCALE 1:2

**D3494-1F STUB COVER FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.060 THICK) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 36863
Description: STUB COVER		Part Number: D3494-1
Inspection Dwg: D3494-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.208	+/- .010	.208	X			
2.68	+/- .010	.268	X			
3.25	+/- .010	.325	X			
7.23	+/- .010	.723	X			
2.442	+/- .010	2.442	X			
2.540	+/- .010					
2.540	+/- .010	2.540	X			
6.103	+/- .010	6.103	X			
6.201	+/- .010					
6.201	+/- .010	6.201	X			
7.920	+/- .010	7.920	X			
8.318	+/- .010	8.318	X			
8.643	+/- .010	8.643	X			
1.768	+/- .010	1.768	X			
1.773	+/- .010	1.773	X			
3.223	+/- .010	3.223	X			
3.566	+/- .010	3.566	X			
7.506	+/- .010	7.506	X			
7.848	+/- .010	7.849	X			
9.298	+/- .010	9.298	X			
9.303	+/- .010	9.303	X			
11.071	+/- .010	11.071	X			

Measured by: IB
Date: 8-1-21

Audited by: [Signature]
Date: 08/01/21

Prototype Approval: [Signature]
Date: [Signature]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]